Dart Aerospace Ltd. Thursday, 4/12/2007 8:46:31 AM Kim Johnston Ußer: **Process Sheet Drawing Name** : LUG . : CU-DAR001 Dart Helicopters Services Customer Job Number : 31737 : 10008 **Estimate Number** Part Number : D2591 P.O. Number : NIA S.O. No. : 1) A · D2591 REV D : 4/12/2007 **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : NIA : MACHINED PARTS First Issue Type **Drawing Revision** : 31231 : JIA Previous Run Material Qty: : 5/5/2007 Each Due Date 60 Um: Written By Checked & Approved By 05-10-25 Comment : Est Rev:I Removed from 9 Digit **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: ASTM A21 Steel .75"x2.5" 1.0 Comment: Qty.: 0.2340 f(s)/Unit Total: 14.0400 f(s) ASTM A36 Steel bar 2.50" x 0,75" thick(M1010-B0.750X02.500) 60 Batch: M103069 x 19 parts 2.0 Comment: BAND SAW Cut blanks: 2.700" long HAAS1 HAAS CNC VERTICAL MACHINING #1 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC8 Comment: SECOND CHECK 6.0 PACKAGING PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock

. Page 1

Location:

Form: rorocess

Dart Aerospace Lt

W/O:		e e e	WORK ORDER (·				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
Part No):	PA	R #: Fault Category:	NCR: Yes	No) DQ	A: 🗲	Date: _	0105/01

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Varification		A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

Dåte:

Thursday, 4/12/2007 8:46:31 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31737

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 57.08.01

Dart Aerospace Ltd

			WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		DAP #: Fault Category	DAD #						

Part No:		PAR #:	Fault Cate	gory:	NCR: Yes N	o DQA :	Date: _	·
			e.		QA: N/0	Closed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	n B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31737
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Oomments
1.20	+/-0.030	1,203"				
Ø0.510	+/-0.010	0,509"				
0.125	+/-0.010	130"				
2.44	+/-0.030	2,440"				
0.65	+/-0.030	,654"				
0.50	+/-0.030	,503"				
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Measured by: 5	·F	Audited by:	ir.	Prototype Approval:	N/A
Date: 07	1/04/26	Date:	07/04/26	Date:	N/A

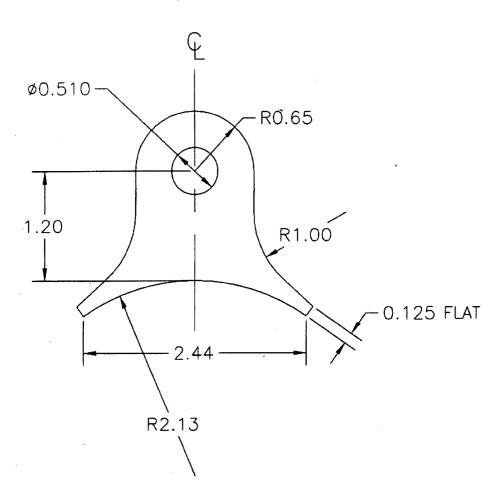
Rev	Date	Change		 Revised by	Approx/ed
Α	04.08.12	New Issue	P/O D205-641-011 & DSI 9161-011	KJ/JLM A	





	DESIG	TOOK	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
1	CHECH	(EP_	APPROVED	DRAWING NO.	REV. D
		LE	8W	D2591 SHEET 1	1 OF 1
	DATE	<u></u>	**************************************	TITLE	SCALE
	98.0	1.21		GHW LUG	1:1
	Α		96:09:16	NEW ISSUE	
	В		97:06:17	RE-DESIGN TO FLAT BOTTOM	
	С		97.12.12	RE-DESIGN TO RADIUS BOTTOM	
	ח		98.01.21	0.125 FLAT WAS 0.067 FLAT	





0.063

BREAK ALL SHARP CORNERS 0.010-TO-0.020 MATERIAL: ASTM A36 STEEL 0.50 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE TROTED COPY
PART IS SYMMETRIC ABOUT CENTER-LINE SUBJECT TO AMENDMENT

ENGINEERING WITHOUT NOTICE

WORK ORDER

SHOP COPY

RETURN TO

ALL DIMENSIONS ARE IN INCHES

